Work Order ID 108050 October-07-13 9:10:03 AM				*108				Page 1			
Item ID: Revision ID: Item Name:	D3912-5 Eyebolt Plate	;		Accept	*N900	<b>040</b>	100	)* s	etup Sta	rt *N P *N	S1* S2*
Start Date: Required Date: Reference:	10/07/13 : 10/07/13	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item II Customer:	D:					
Approvals:		an: MLS	Date: \2-10-0\{		Date:			R	tun Sta Sto		R1*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool#		Accept Qty	Reject Qty	Reject Number	R2* Insp. Stamp
Draw Nbr	Re	vision Nbr		. ,							
D3912 100 *100* Waterjet FLOW CNC Waterj	B	<b>Memo</b> Cut as per dy		0.00				. 12	0		Jm13-11-5
४०५ । १३५	•	Prog Rev: Dwg Rev: Deburr as rec	8								

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

Memo

0.00

Quality Control

									DQA:	Date:	*- •
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Orde	or.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
	Part No.			·	Rework Skid-tube Scrap Machining Use-as-is Thermoforming		~ <del>}</del>	Crosstube Small Fab Finishing	Water Jet Prod. Eng. Coor. Rec/Store/Packaging		Engineering Quality Other
NCR N	No				Work Order Update		Large Fab	Composite			
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other							1				
Process											
Supplier											
Training											
Unapproved			<u> </u>								
					F <i>i</i>	<b>AULT CATE</b>	GORY				
Landi	ng Gear				General				,		-
	Bendin	g			Bend	Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	entric to	o/s	BOM/Route	Hardwa	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushe	d/Crimped	•		Burrs	Instruc	tions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance		Part Moved		
	Heat T	eat			Countersink	Mislab	eled		Positioned V	Wrong	_
	Inspec	Inspection Strip in Tube Cut Too Short		Cut Too Short	Misrea	<del> </del>			'Surge	Other	

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 108050 \*108050\* Page 2 October-07-13 9:10:03 AM Item ID: D3912-5 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Eyebolt Plate **Start Date:** 10/07/13 **Start Qty: 12.00 Cust Item ID:** Required Date: 10/07/13 Req'd Qty: 12.00 **Customer:** Reference: Run Process Plan: Date:\_\_\_\_\_\_ Approvals: **Tooling:** Date: Date: SPC (Y/N): Date: Sequence ID/ Operation Tool ID Tool # Plan Reject Set Up/ Accept Reject Insp. **Work Center ID** Run Hours **Description** Code Qty **Qty** Number Stamp QC8- Inspect parts - second check 0.00 120 \*120\* 0.00 Memo **Quality Control** Identify as per dwg & Stock Location: 57144 130 0.00 \*120\* Packaging 0.00 Memo Packaging 140 QC21- Final Inspection - Work Order Release 0.00

0.00

Memo

\*140\*

Quality Control

QC

H13-11-07 11-01

									DQA:	Date:	<u> </u>
NCR: Y	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	DATE			
	.• •								QA Closed:	Date:	
Work Orde	r <del>i.</del>				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
	···			<del></del>	Rework	Skid-tube Crosstube Water Jet En				Engineering	
Part N	lo.				Scrap					Quality	
					Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	
Root		1	[	Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	ı	or Non-conformance	Chief Eng	1	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup		1									
Other		1									
Process		}									
Supplier											
Training			1								
Unapproved											
					F	AULT CATI	GORY			· · ·	
Landir	ng Gear				General				-	·	•
	Bending			<u> </u>	Bend	Grain			Ovalized	<u></u>	Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
		/Crimped			Burrs	$\blacksquare$	tions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance	<u></u>	Part Moved		
	Heat Tre	at			Countersink	Mislab	eled		Positioned \	Vrong	
	Inspection	on Strip in	Tube		Cut Too Short	Misrea	ıd -		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Page 1

Work Order ID:

108050

Parent Item:

D3912-5

Parent Item Name:

Eyebolt Plate

**Start Date:** 10/07/13

Required Date: 10/07/13

Start Qty: 12.00

136075

Required Qty: 12.00

Comments:

IPP RevA: new issue DD 09.11.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No			100	sf	218.0633	0.05125	.0. <del>647368</del> 8	0.75	<b>&gt;</b>	JM13-11-5
				<b>Location</b>		Loc Qty	<u>L</u> c	oc Code					
				MAT020		218.0632632							

19.1432632

44.5

154.42

122521

124445

M126075

									DQA:	Date:	• •
NCR: Yes	s / No			١	WORK ORDER NON-C	CONFOR	MANCE / UP	DATE	QA Closed:	Date:	
Work Order:	:			DISPOSITION AGAINST DEPARTMENT/PROCESS							
Part No	).				Rework Scrap Use-as-is Work Order Update		Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	+	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description	on of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	or N	Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data											·
Equip/Tooling		l									
Operator									Ì		
Material									İ		
Setup	_	ļ									
Other		Ì									
Process					•						
Supplier											
Training											

**FAULT CATEGORY** 

Landing	Gear	General		_	_	_
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
Γ	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Г	Maintenance	Part Moved	_
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 _
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio	Γ	Outside Dimensions		

Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	108050
Description: Eyebolt Plate	Part Number:	D3912-5
Inspection Dwg: D3912 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

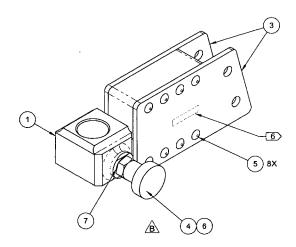
Drawing	T-1	Actual	A A	Baisat	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.129	+0.005/-0.001	0.129"	_		V	Thmor
Ø0.257	+0.006-0.001	0.328"	u u		U	
0.38	+/-0.030	0.383"	_		V	
1.500	+/-0.010	1.501"	_		V	
0.500 Pitch	+/-0.010	0.502"	_		V	
3.15	+/-0.030	3.15"	_		Ú	
0.375	+/-0.010	0.376	~		V	
0.517	+/-0.010	0.519"	_		V	
1.000	+/-0.010	1.000"	-		V	
3.65	+/-0.030	3029,	_		V	
1.500	+0.020/-0.000	1.501"	-		V	
0.25	+/-0.030	0.256"	<u> </u>		V	
2.00	+/-0.030	2.010"	_		V	
0.125	+/-0.010	0.116"	_		V	
	,					

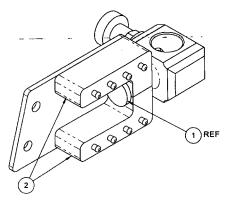
Measured by: Jm	Audited	1 by: 5M		Preliminary Approval:	
Date: 3-11-5	D	Date: 13 1	15	Date:	

Rev	Date	Change	Revi	sed b	у	Approved
Α	10.06.07	New Issue	KJ	1	Δ	1.1
В	10.08.09	Dwg Rev updated	KJ	<b>A</b>		14
				7	7	

" ITEK	QTY -041	P/N	DESCRIPTION	
	Х	D3912-041	EYEBOLT RECEIVER ASSY	
1	1	D3912-1	EYEBOLT	7
2	2	D3912-3	EYEBOLT BLOCK	
3	2	D3912-5	EYEBOLT PLATE	□ .
4	1	D3801-1	SPRING PLUNGER	
5	8	-MS20615-4M20	RIVET	
6	1	MS21209-F615	HELICAL	☐ <i>/</i> ê
7	1	NAS1149F0332P	WASHER	/8







SUPPLEMENTAL ISO VIEW (EYEBOLT PLATE REMOVED TO SHOW INTERIOR FEATURES)

13-10-08



## **D3912-041 EYEBOLT RECEIVER ASSY**

NOTES: 1) MATERIAL: N/A 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER

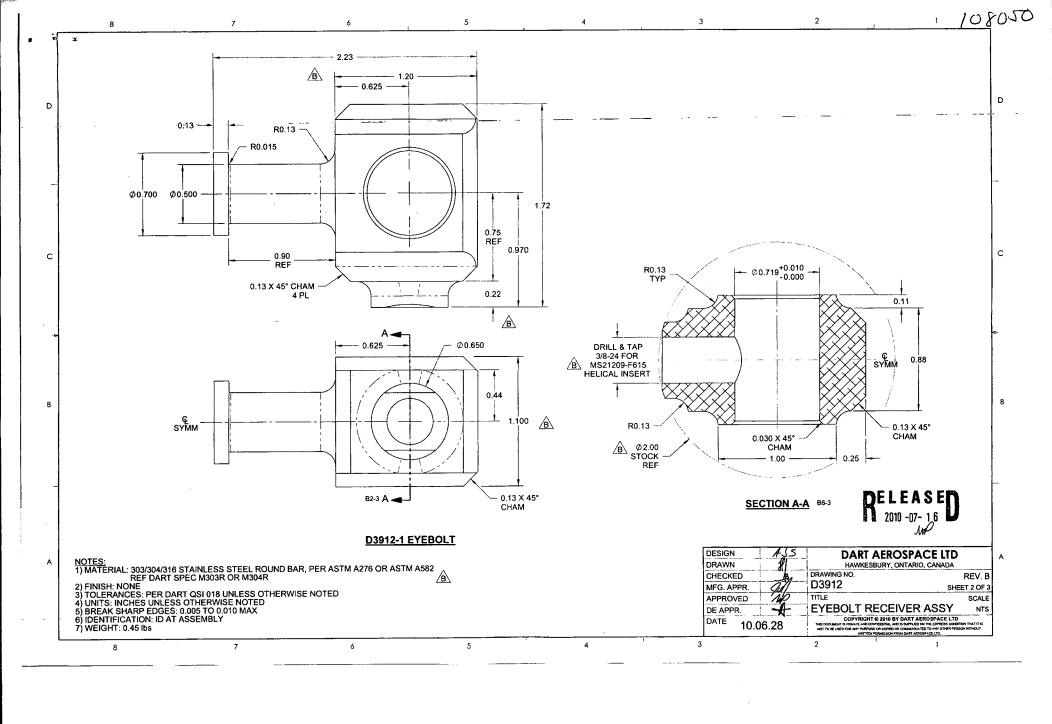
7) WEIGHT -041: 1.58 lbs

8

D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0663R ADDED; BOSS ADDED TO D3912-1. 10.06.28 NEW ISSUE 10.03.04 Α DESCRIPTION DATE REV. DESIGN

DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D3912 MFG. APPR. SHEET 1 OF 3 APPROVED TITLE SCALE EYEBOLT RECEIVER ASSY NTS DE APPR. COPYRIGHT © 2010 BY DART AEROSPACE LTD
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D - 3.15 1.500 2.30 0.500 PITCH R0.13 0.800+0.000 TYP Ø0.129 THRU 0.38 1.500 0.400 0.500 PITCH 0.25 0.517 0.50 REF 1.00 0.750 +0.000 -0.020 1.000 1.500+0.020 R0.13 0.500 2.00 R0.125 TYP 0.516+0.015 0.63 REF Ø0.129 Ø0.257 8 PL 0.125 2 PL REF **D3912-3 EYEBOLT BLOCK** 3.65 3.69 REF **D3912-5 EYEBOLT PLATE** NOTES: 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M303B OR M304B -5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240 REF DART SPEC M303S11GA OR M304S11GA DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA 2) FINISH: NONE DRAWING NO. 2) FINISH: NOTE:
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ID AT ASSEMBLY CHECKED REV. B D3912 MFG. APPR. SHEET 3 OF 3 TITLE APPROVED SCALE EYEBOLT RECEIVER ASSY DE APPR. NTS 7) WEIGHT -3: 0.30 lbs -5: 0.24 lbs COPYRIGHT © 2010 BY DART AEROSPACE LTD
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